

**DART**

DESIGN QP	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED QP	APPROVED H	DRAWING NO. DSI 9329	REV. B SHEET 1 OF 1
DATE 06.06.26	TITLE BUBBLE WINDOW INSTALL MOD.		SCALE NTS
A	06.04.25	NEW ISSUE	
B	06.06.26	CHG TO EFFECTIVE AFTER CHG 002	

## **DART SERVICE INSTRUCTION**

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-713 REV. A**  
REF. CANADIAN STC: SH05-13 ISSUE 1  
REF. FAA STC: SR02088NY

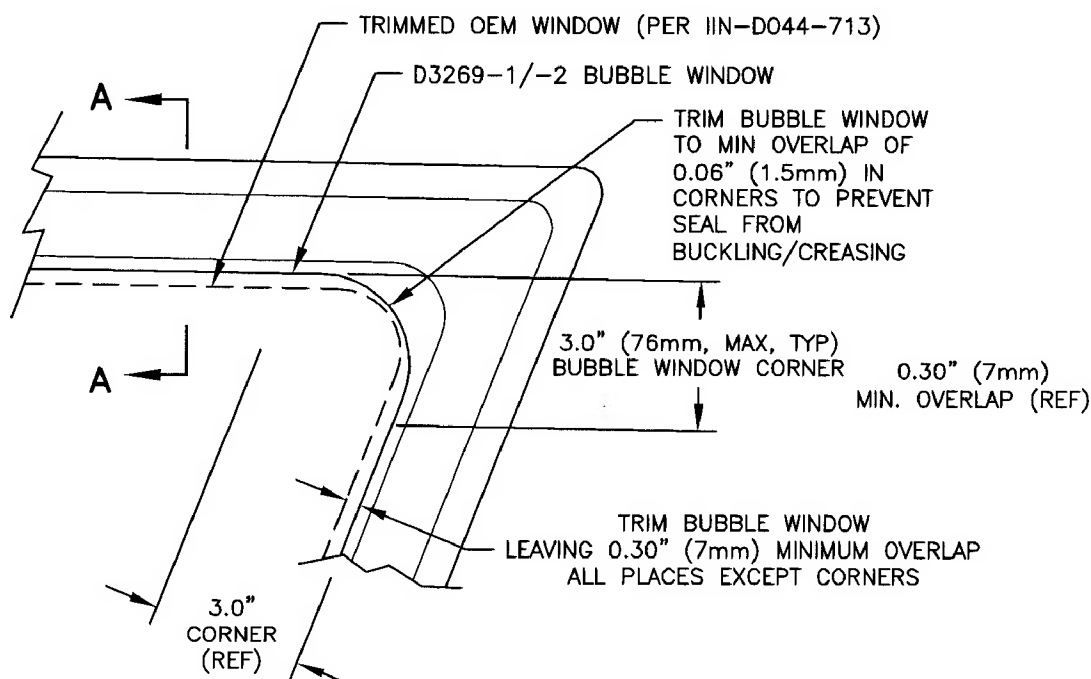
**PURPOSE:** For the D044-713-013/-014 kits supplied after CHG 002, the D3267-1/-2 bubble windows have been supplied untrimmed to allow for easier installation in the field. The installer must trim the windows in accordance with these instructions prior to installation.

### **PROCEDURE:**

- 1) Modify the R44 crew door per items 3.2.1 and 3.2.2 of Installation Instructions IIN-D044-713 Rev.A.
- 2) Fit and trim the D3269-1/-2 Bubble Window to match the cutout in the door as follows: The bubble window must be a minimum of 0.30" (7mm) larger than the cutout in the OEM window as shown in the figure below. However, in the corners of the window, it is acceptable to trim a 0.06" minimum overlap (1.5mm) to help prevent the D2126-0903 Seal from buckling/creasing in the corners. The edge of the bubble window must be deburred to a smooth finish.
- 3) Continue installing the bubble window per items 3.2.3 through 3.2.5 of the installation instructions.

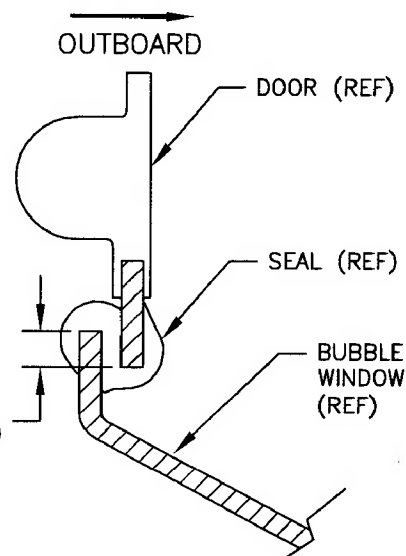
**FIGURE 1**

LOOKING AT INSIDE CORNER OF DOOR



**SECTION A-A**

(NOT TO SCALE)



CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY:   
D. SHEPHERD (DE # 02)

DATE: 06.06.26  
CERT. NO.: SH05-13  
ISSUE NO.: 1

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